

4

Date: Thursday, 1/17/2008 3:30:08 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DECK PLATE KIT
 Job Number : 36834
 Estimate Number : 11233
 P.O. Number :
 This Issue : 1/17/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1 / Type : SMALL / MED FAB
 Previous Run : 36240
 Part Number : D350616015
 Drawing Number : D350-616 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 1/24/2008 Qty: 2 / Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:C Removed Manufacturing 05-12-05 JLM
 Est Rev:D Add D3494-1 05-12-05 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D350-616-015 CHG002

K-808.01.21

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D2344 Deck Plate, Aft, 350 Litt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2344 Deck Plate (Aft)

B11817

(1x)

33262

(1x)

30

4.0 D2348 Wear Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2348 Wear Plate (Key Way)

B17149

(1x)

B31919

(1x)

B27734

(1x)

5.0 D2353 Stiffener



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2353 Stiffener

B15449

(1x)

B31920

8/2/21

30

(2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:30:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 36834

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2364

Deck Plate, Fwd 350 Litt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2364 Deck Plate (Fwd)

1211843 (1x)

1331921 (1x)

SP

7.0

D2365

Wear Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2365 Wear Plate (Pip Pin)

18379 (2x)

133673 (2x)

SP

8.0

D23691

Template



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2369-1 Locator Plate

1311698

1335241

SP

9.0

D23693

Template



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2369-3 Locator Plate

18351

1331923

SP

10.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN960JD10 Washer

1106167

SP

11.0

MS20426AD45

Rivet



Comment: Qty.: 25.0000 Each(s)/Unit Total : 75.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

25 MS20426AD4-5 Rivet

13459

8/2/21

(2x)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 36834

Part Number: D350616015

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	MS20426AD46	Rivet
------	-------------	-------



Comment: Qty.: 25.0000 Each(s)/Unit Total : 75.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

25 MS20426AD4-6 Rivet

M2525

(25x)

M103395 SP

13.0	MS20426AD57	Rivet
------	-------------	-------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS20426AD5-7 Rivet

M3876

(6x)

M7681

(6x)

SP

14.0	MS20426AD58	Rivet
------	-------------	-------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS20426AD5-8 Rivet

M3310

(6x)

M4533

(6x)

SP

15.0	MS20601AD4W2	Rivet
------	--------------	-------



Comment: Qty.: 15.0000 Each(s)/Unit Total : 45.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 MS20601AD4W2 Blind Rivet

M104214

* 1 kit has 1 extra

SP

16.0	MS20601AD4W3	Rivet
------	--------------	-------



Comment: Qty.: 30.0000 Each(s)/Unit Total : 90.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

30 MS20601AD4W3 Blind Rivet

M13044

(30x)

M8325

(30x)

8/2/21 SP

(2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:30:09 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 36834

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L3 Nut (or -3) M106242

34

18.0

MS24693C48

Screw



Comment: Qty.: 22.0000 Each(s)/Unit Total: 66.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

22 MS24693-C48 Screw (or -48) M5150 (2x)

M12620 (2x)

19.0

MS24693C273

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS24693-C273 Screw (or -273) M9599 (2x)

M12620 50 (2x) 8/2/22

20.0

D34941

STUB COVER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

STUB COVER

Batch: 28946

Re-enter in stock

AR 08/01/22 (2)

21.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

20807-22 (2)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-616-015

Location: C

PPP Rev: 28/2/22 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 08/02/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:30:09 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 36834

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

2008/2/22

Job Completion



2008/2/22

(2)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DESIGN BW	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D350-616	REV. D SHEET 1 OF 13
DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION	SCALE NTS
A	95.02.20	NEW ISSUE	
B	96.01.09	ADD VIEW OF D2493 TO SHEET 9	
C	06.01.10	ADD DSI 9112/9117/9130/9236/9310	
D	06.01.19	ADD D3494-1 STUB COVER	

QTY - 011	Qty - 013	Qty - 015	Part Number	Description
X			D350-616-011	Full Litter Kit
1	X		D350-616-013	Deck Plate and Tie Down Kit
	1	X	D350-616-015	Deck Plate Kit
		1	D2344	DECK PLATE (AFT)
		4	D2348	WEAR PLATE (KEY WAY)
	1		D2350	LITTER TIE DOWN (NON-LOCKING)
		1	D2353	STIFFENER
	1		D2360	LITTER TIE DOWN (LOCKING)
		1	D2364	DECK PLATE (FWD)
		2	D2365	WEAR PLATE (PIP PIN)
		1	D2369-1	LOCATOR PLATE
		1	D2369-3	LOCATOR PLATE
1			D2370	LITTER ASSEMBLY
1			D2493	PATIENT STOP
		1	D3494-1	STUB COVER
		10	AN960JD10	WASHER
		25	MS20426AD4-5	RIVET
		25	MS20426AD4-6	RIVET
		6	MS20426AD5-7	RIVET
		6	MS20426AD5-8	RIVET
		15	MS20601AD4W2	BLIND RIVET (OR CR9162-4-2)
		30	MS20601AD4W3	BLIND RIVET (OR CR9162-4-3)
		22	MS24693-C48	SCREW (OR MS24693-48)
		6	MS24693-C273	SCREW (OR MS24693-273)
		6	MS21042L3	NUT (OR MS21042-3)
		4	MS35207-264	SCREW

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36834

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	06.01.19
CERT. NO.:	SH96-10
ISSUE NO.:	2

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CHECKED 	APPROVED 	DRAWING NO. D350-616	REV. D SHEET 2 OF 13
DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION SCALE NTS	

GENERAL NOTES:

1. COMPATIBILITY

COMPATIBILITY OF THIS INSTALLATION WITH THE AIRCRAFT IS THE RESPONSIBILITY OF THE INSTALLER. ENSURE THAT THIS INSTALLATION DOES NOT CONFLICT WITH A PREVIOUS MODIFICATION.

2. WORKMANSHIP

UNLESS OTHERWISE STATED, ALL WORKMANSHIP SHOULD BE TO THE STANDARD SET BY THE AIRCRAFT MAINTENANCE MANUAL.

3. INSTALLATION INSTRUCTIONS

THIS DRAWING IS TO BE USED IN CONJUNCTION WITH INSTALLATION INSTRUCTIONS IIN-D350-616.

4. CONTINUING AIRWORTHINESS

THIS INSTALLATION SHOULD BE MAINTAINED IN ACCORDANCE WITH MAINTENANCE MANUAL SUPPLEMENT MMS-D350-616.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-616-011 Full Litter Kit	31.3 lb 14.19 kg	17.3 in 0.44 m	541.5 in-lb 6.24 m-kg	63.8 in 1.62 m	1996.9 in-lb 22.99 m-kg
D350-616-013 Deck Plate & Tie Down	6.3 lb 2.86 kg	15.4 in 0.39 m	97.0 in-lb 1.12 m-kg	52.0 in 1.32 m	327.6 in-lb 3.78 m-kg
D350-616-015 Deck Plate Kit	2.8 lb 1.27 kg	15.6 in 0.40 m	43.7 in-lb 0.51 m-kg	53.0 in 1.35 m	148.4 in-lb 1.71 m-kg
Person Approximate CG	lb kg	18 in 0.46 m	in-lb m-kg	72 in 1.88 m	in-lb m-kg

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DAO # 01-O-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

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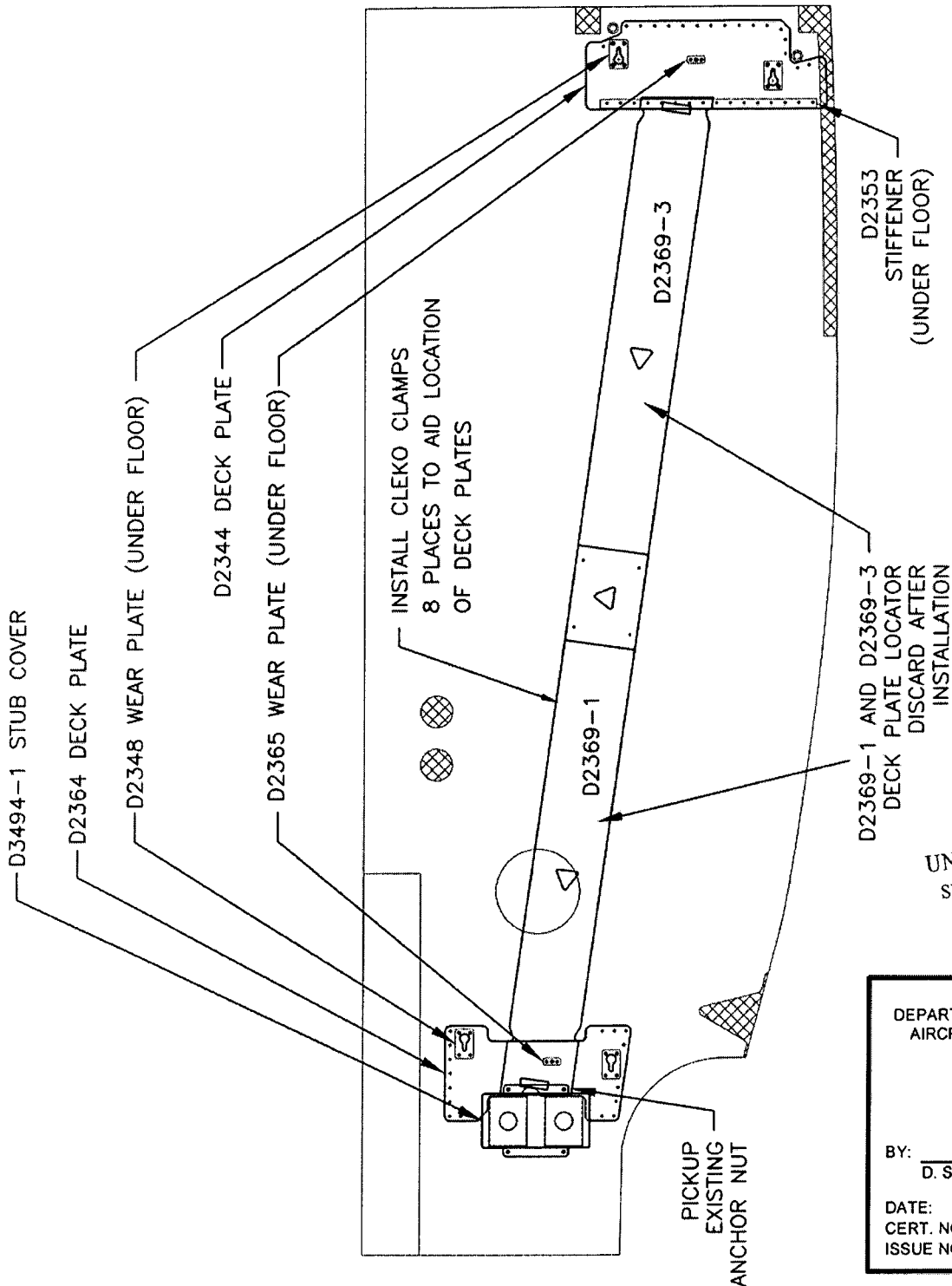


FIGURE 1

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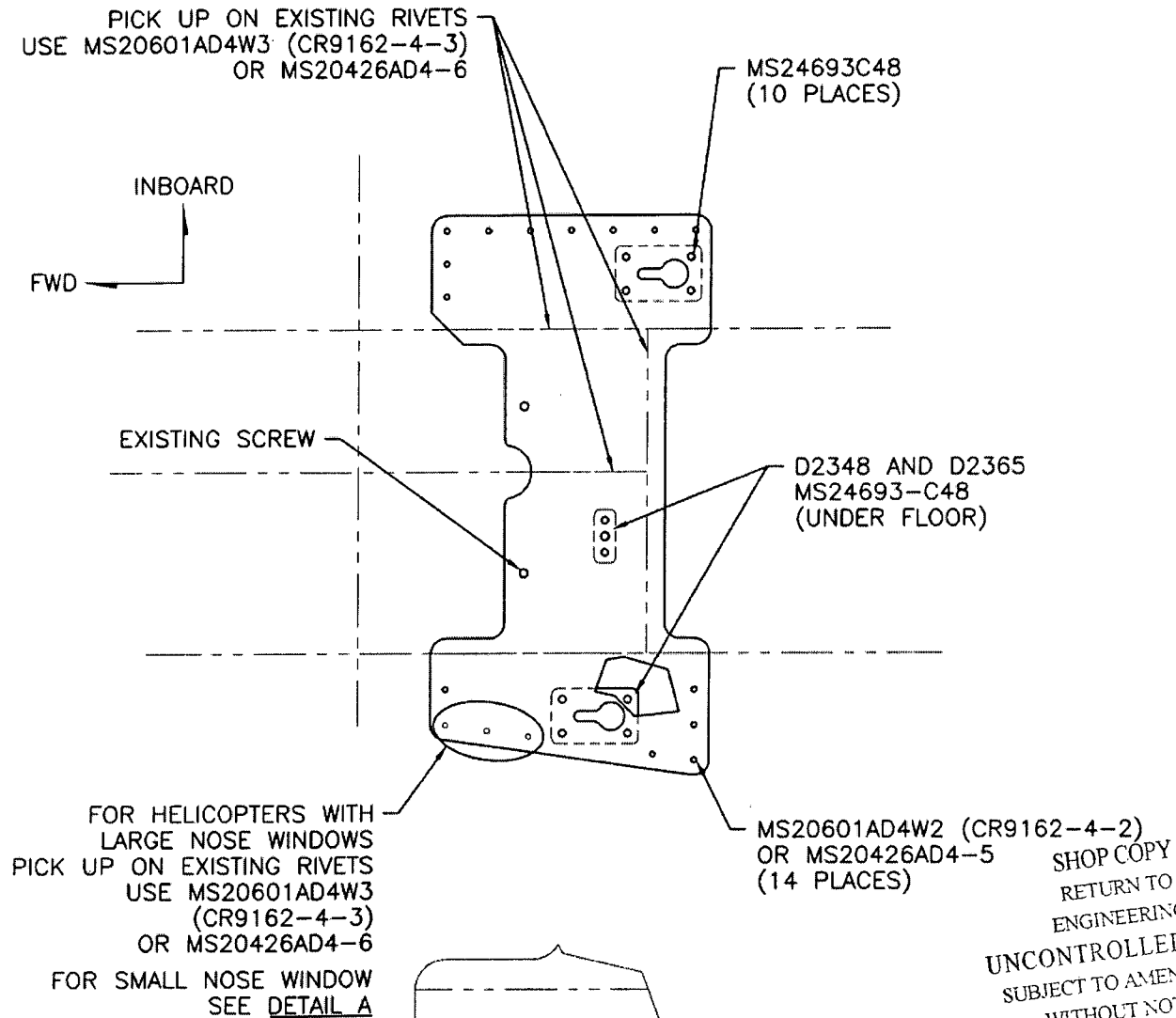
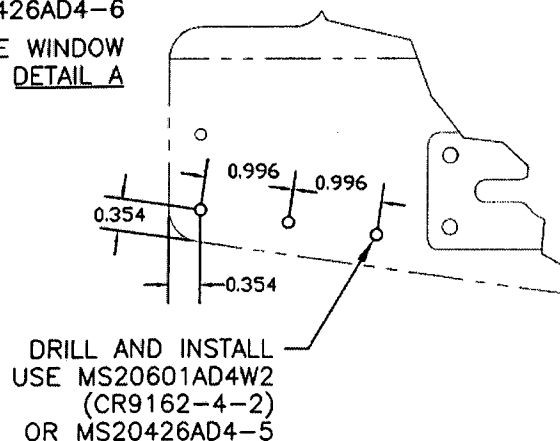
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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS

**FIGURE 2****DETAIL A**

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BY:	D. SHEPHERD (DE # 02)
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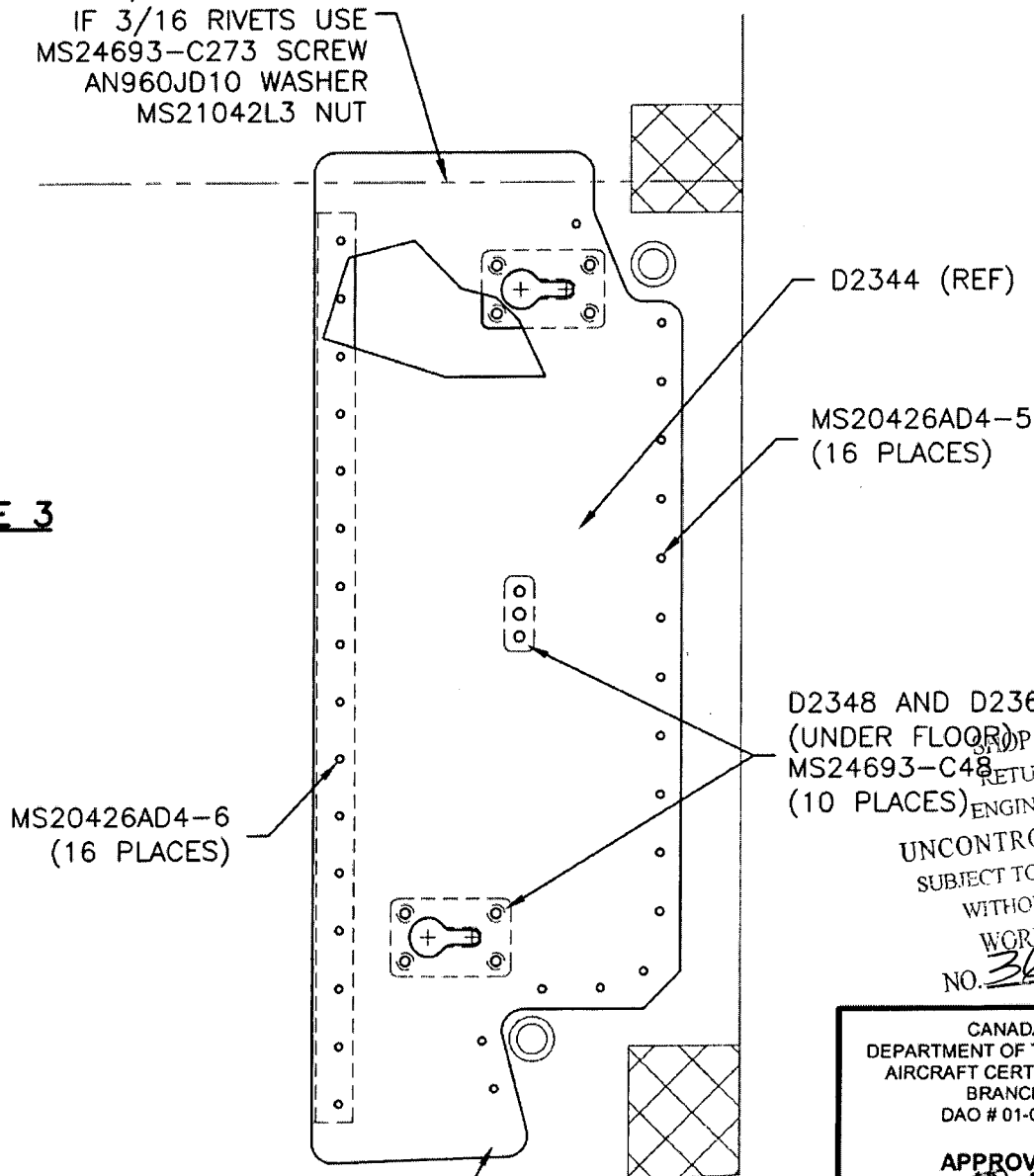
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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS

PICK UP ON EXISTING RIVETS
IF 5/16 RIVETS USE
MS20426AD5-7/MS20426AD5-8
IF 3/16 RIVETS USE
MS24693-C273 SCREW
AN960JD10 WASHER
MS21042L3 NUT

FIGURE 3

MS20426AD4-6
(16 PLACES)

D2344 (REF)

MS20426AD4-5
(16 PLACES)

D2348 AND D2365
(UNDER FLOOR) COPY
MS24693-C48 RETURN TO
(10 PLACES) ENGINEERING
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PICK UP ON EXISTING RIVETS
USE MS20426AD4-6

CANADA
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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

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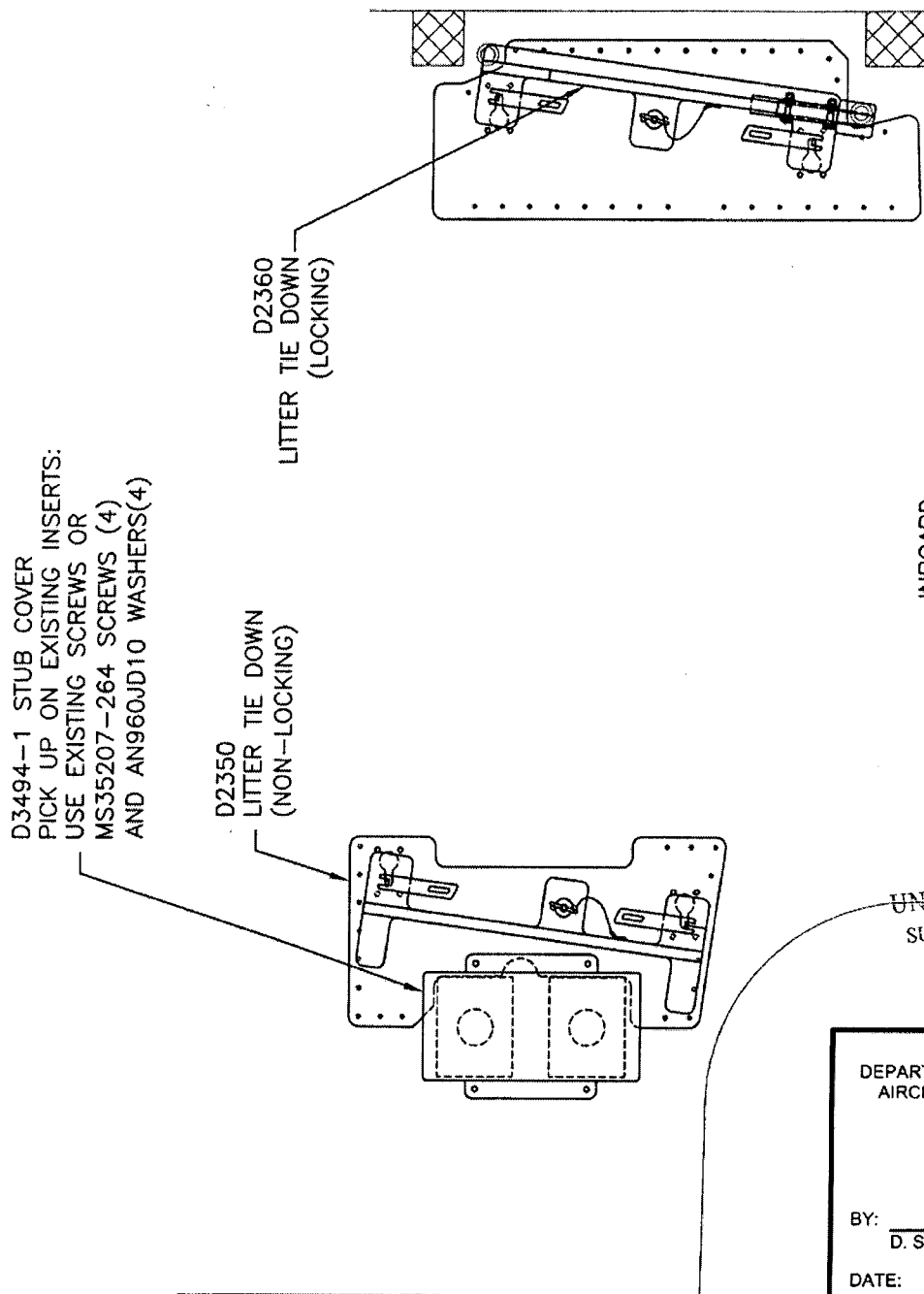
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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS

FIGURE 4: LITTER TIE DOWN INSTALLATION



INBOARD

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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS

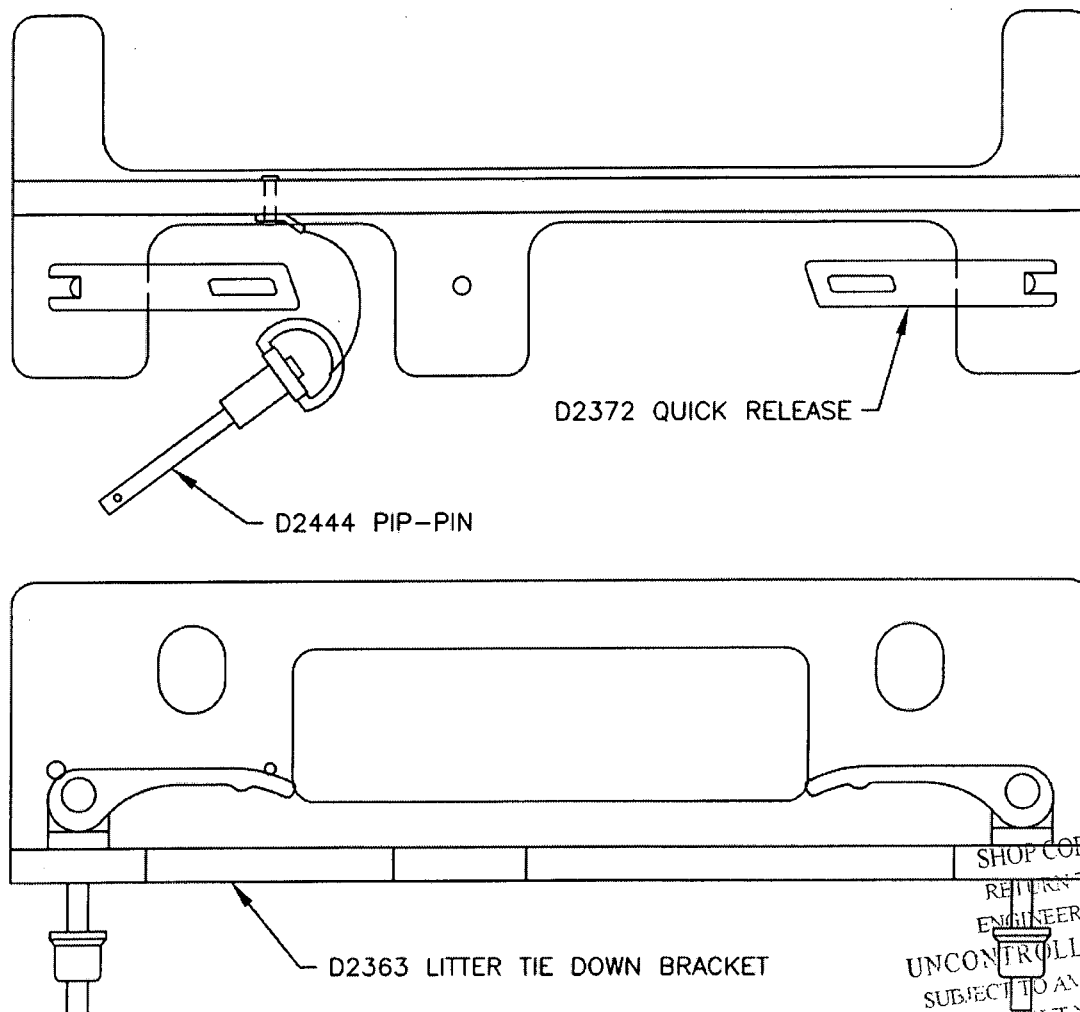


FIGURE 5: D2350 LITTER TIE DOWN ASSEMBLY
(PART REFERENCE)

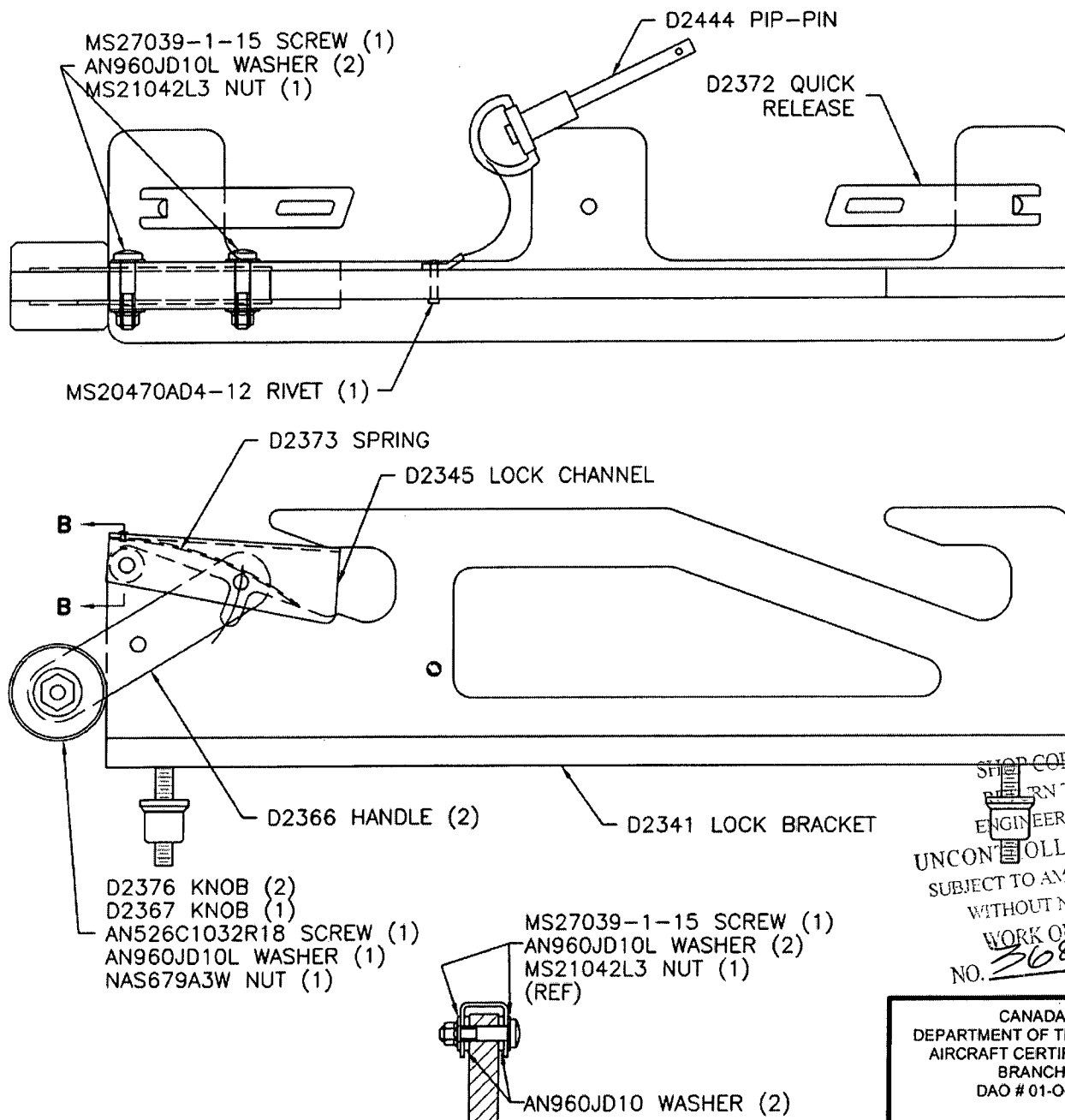
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BY:	D. SHEPHERD (DE # 02)
DATE:	06.01.19
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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS



SECTION B-B

FIGURE 6: D2360 TIE DOWN ASSEMBLY
(PART REFERENCE)

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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS

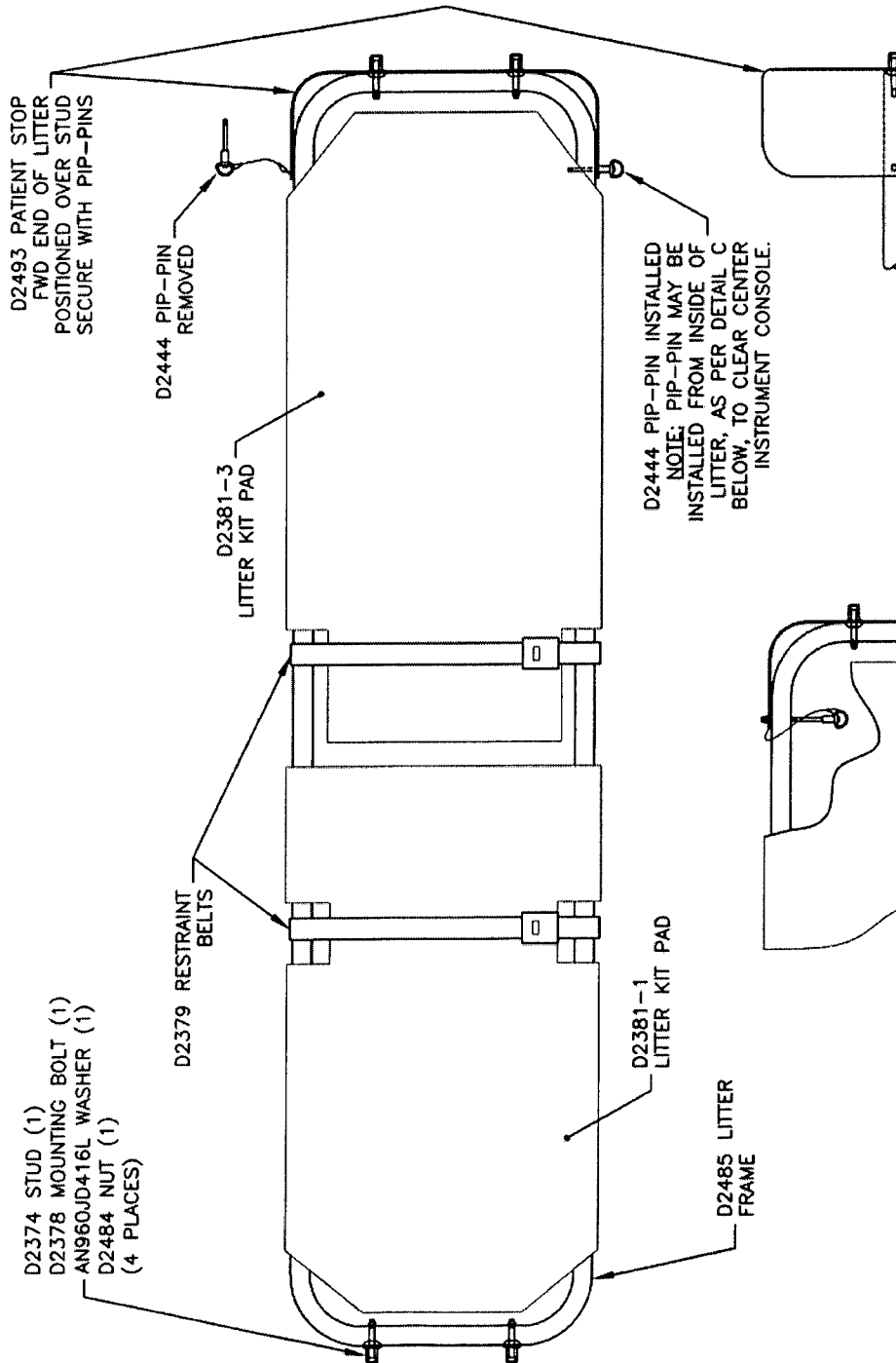


FIGURE 7: D2370 LITTER ASSEMBLY
(PART REFERENCE)

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CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	06.01.19
CERT. NO.:	SH96-10
ISSUE NO.:	2

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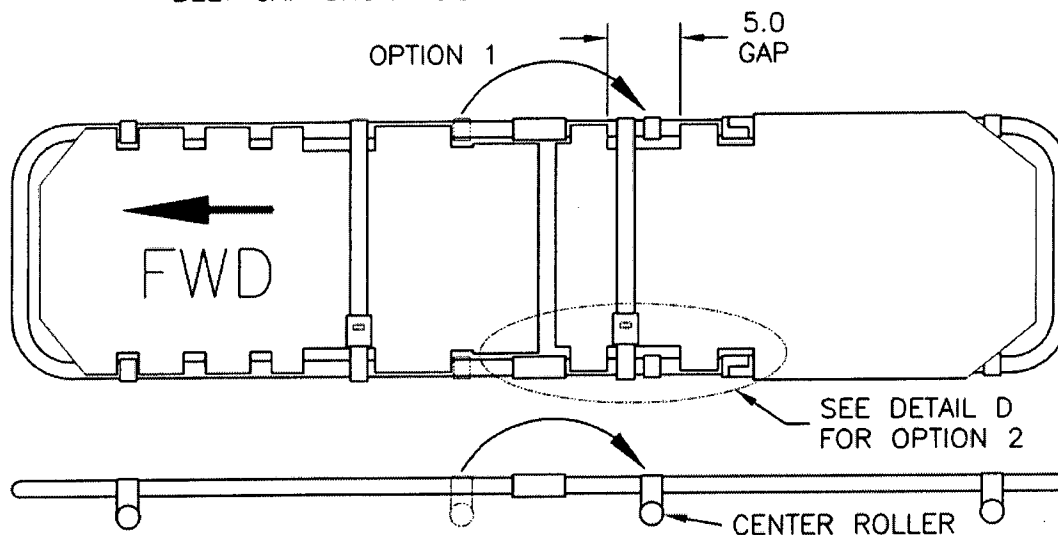


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DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION	SCALE NTS

COMPATIBILITY WITH ENERGY ATTENUATING SEATS

TO FACILITATE INSTALLATION OF THE D350-616-011 LITTER KIT WITH THE SEAT RAILS OF THE ENERGY ATTENUATING SEATS, IT IS ACCEPTABLE TO MOVE THE CENTER ROLLER SUPPORT AFT AS INDICATED:

OPTION 1. MOVE THE CENTER ROLLER ANYWHERE WITHIN THE 5.0" WIDE BELT GAP SHOWN BELOW.



OPTION 2. FOR COMPATIBILITY WITH EXTENDED SEAT RAILS, IT IS ALSO ACCEPTABLE TO CUT A 1.125" WIDE x 1.00" DEEP SLOT FOR INSTALLATION OF THE CENTER ROLLER JUST BEFORE THE HEADREST HINGE AS SHOWN BELOW. ENSURE THE SLOT IS CENTERED BETWEEN THE RIVETS AND LEAVES MAX. EDGE DISTANCE POSSIBLE.

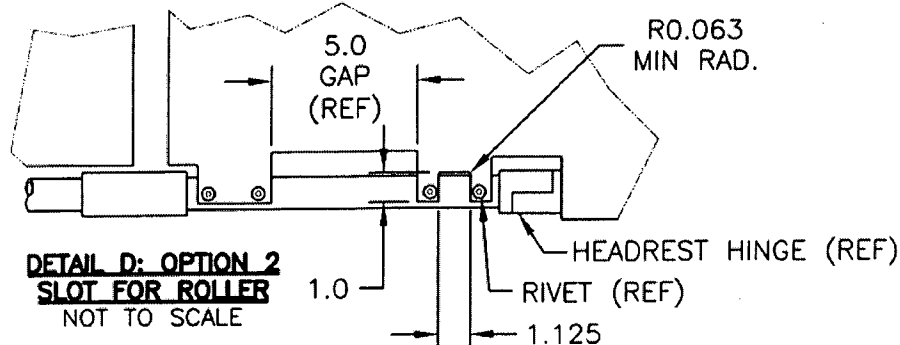


FIGURE 8: CENTER ROLLER RE-LOCATION

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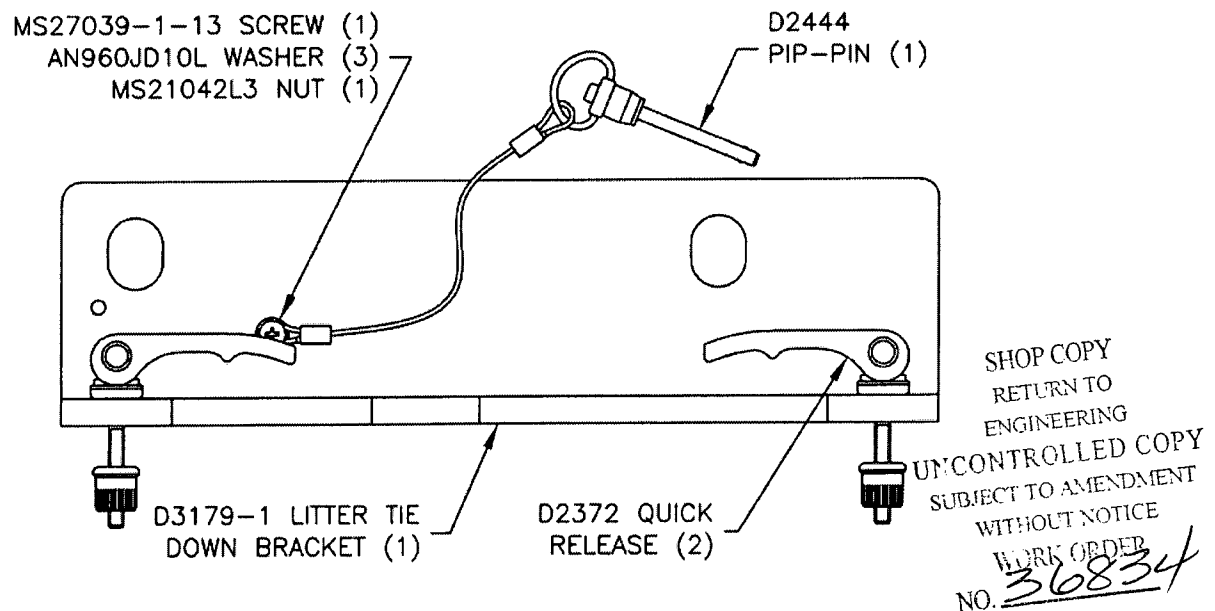
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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE 1:2

COMPATIBILITY WITH GENEVA CONSOLE

FWD LITTER TIE DOWN BRACKET D3179-041 CAN BE USED IN LIEU OF D2350 LITTER TIE DOWN BRACKET REFERRED TO IN THE PARTS LIST FOR COMPATIBILITY WITH THE GENEVA CONSOLE. TO ASSEMBLE D3179-041, ORDER D3179-1 FROM DART AND TRANSFER HARDWARE FROM D2350 AS SHOWN BELOW. IT IS ACCEPTABLE TO TRIM D3179-1 AS REQUIRED FOR FIT AS LONG AS A MINIMUM EDGE DISTANCE OF 0.250" IS MAINTAINED FROM THE EDGE OF ALL HOLES AND SLOTS. PRIME AND PAINT IN ACCORDANCE WITH THE AIRCRAFT MAINTENANCE MANUAL PRIOR TO FINAL INSTALL.



**FIGURE 9: D3179-041 FWD
LITTER TIE DOWN**

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DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION	SCALE NTS

COMPATIBILITY WITH SLIDING DOORS

AIRCRAFT EQUIPPED WITH A SLIDING DOOR CAN BE MODIFIED AS FOLLOWS TO BE COMPATIBLE WITH D350-616-011 LITTER KIT.

- (1) TRIM D2344 DECK PLATE TO WITHIN 0.05" OF THE DOOR RAIL AS SHOWN IN FIGURES 10 & 11. TOUCH UP WITH PRIME AND PAINT AS REQUIRED PER THE AIRCRAFT MAINTENANCE MANUAL.
- (2) DRILL FOUR 0.128" DIAMETER HOLES IN D2344 DECK PLATE AS SHOWN IN FIGURE 11. TOUCH UP WITH PRIME AND PAINT AS REQUIRED PER THE AIRCRAFT MAINTENANCE MANUAL. ATTACH D2344 DECK PLATE PER IIN-D350-616 REV. A. IN THE FOUR DRILLED HOLES, FASTEN TO AIRCRAFT FLOOR SKIN WITH AN ADDITIONAL FOUR MS20426AD4-5 BLIND RIVETS.
- (3) TRIM FAIRING AS SHOWN IN FIGURE 11.

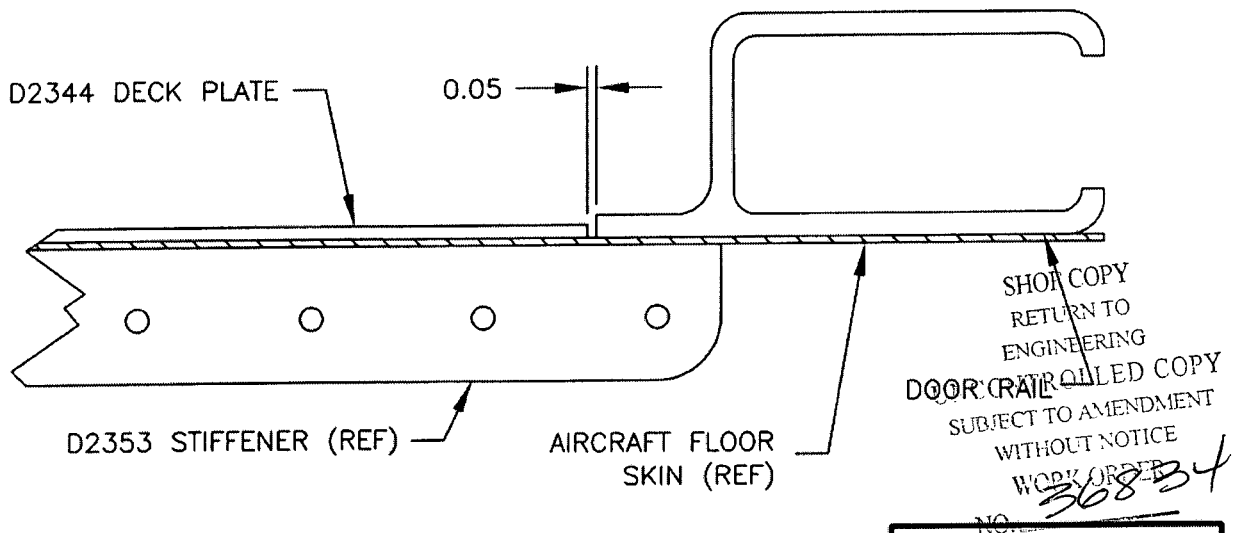


FIGURE 10
VIEW LOOKING AFT

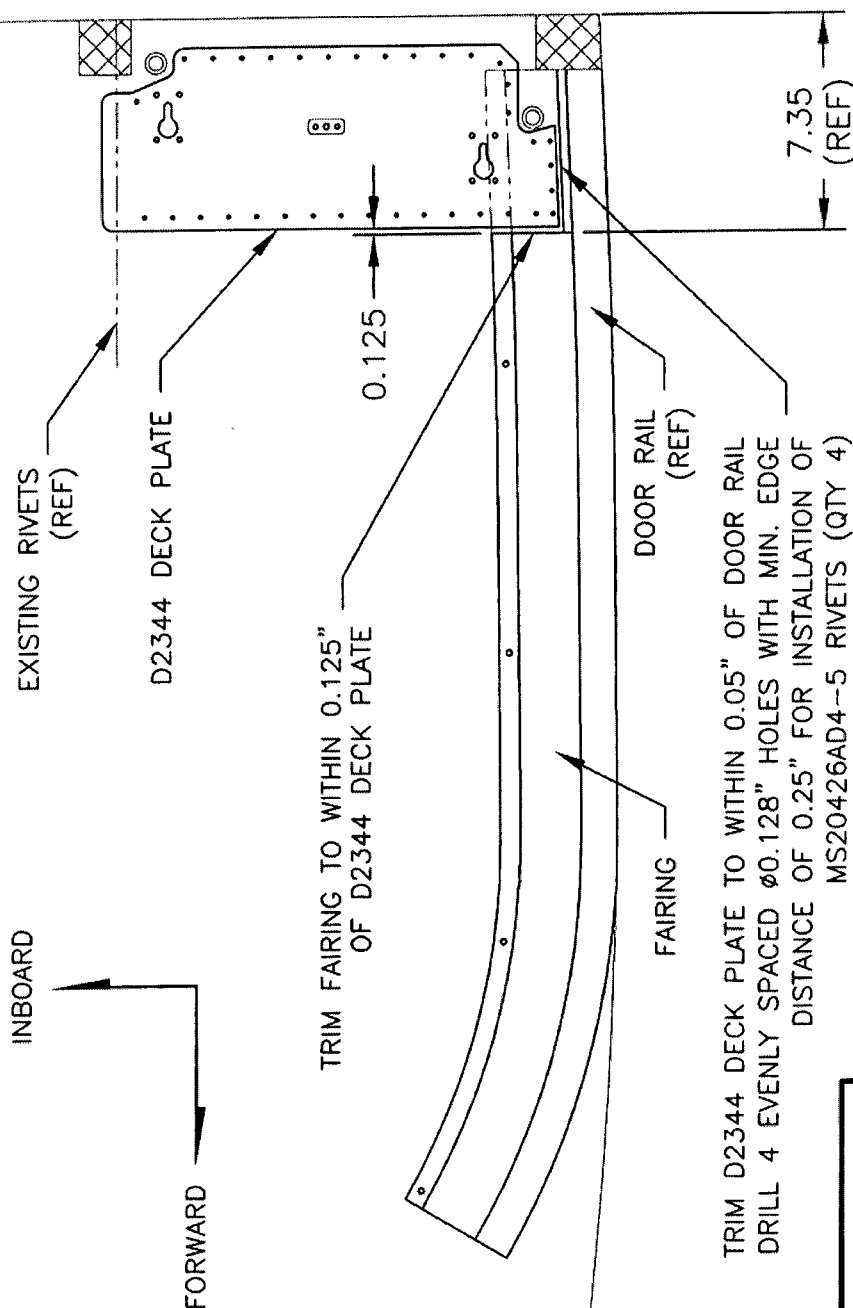
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COMPATIBILITY WITH SLIDING DOORS**FIGURE 11**

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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

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